

Date: Thursday, 6/28/2007 2:21:39 PM  
User: Kim Johnston

Process Sheet

SP17

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 33250	
Estimate Number : 10255	
P.O. Number : <i>N/A</i>	Part Number : D22301
This Issue : 6/28/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2230 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 32163	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/25/2007 Qty: <i>160</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 35.8575 f(s)  
Lug Extrusion D2423 Extrusion  
Batch: *30062*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
Cut D2423 extrusion to 0.82"  
Batch: *[Blank]*

*Issue P/O 4091*

*Machine per Lug D2230 C207107104 (500)*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
1-Machine per folio D2230-1  
(Check for crack while loading into the machine.)  
2-Tumble and deburr rough edges after tumbling

*Receive & Inspect for transit damage*

*SAD 05/13/20*

*160 C/S 07/07/12 160*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC2 SECOND CHECK



Comment: SECOND CHECK


*Inspect Level 5*

*OSP 019*

*2007/07/12 161*

*counted*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 01/07/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 6/28/2007 2:21:40 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 33250

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(161X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.A.

07/07/23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ea 07/07/25 (161)

8.0

POWDER COATING

POWDER COATING



(161)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M 105068

BR/M.A. 07-07-25

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FEL 07/07/25 (161)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Ea 07/07/27 (161)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(161)

Comment: FINAL INSPECTION/W/O RELEASE

Ea 07/07/30

Job Completion



Ea 07-07-30

1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

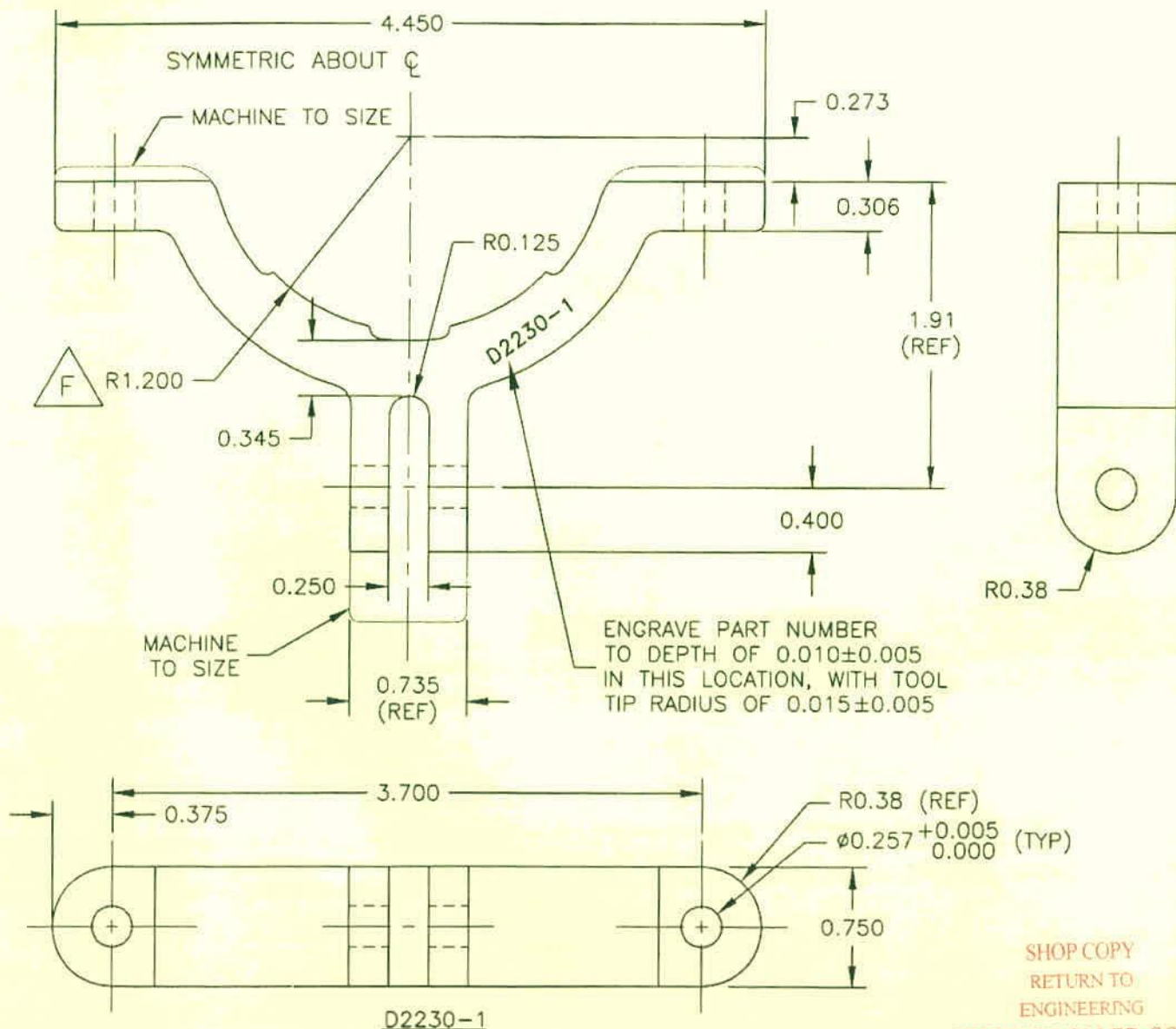
**NOTE:** Date & initial all entries





DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. F
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2230	SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED  
99.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 33250

3.441  
259  
3 708

60  
69  
120

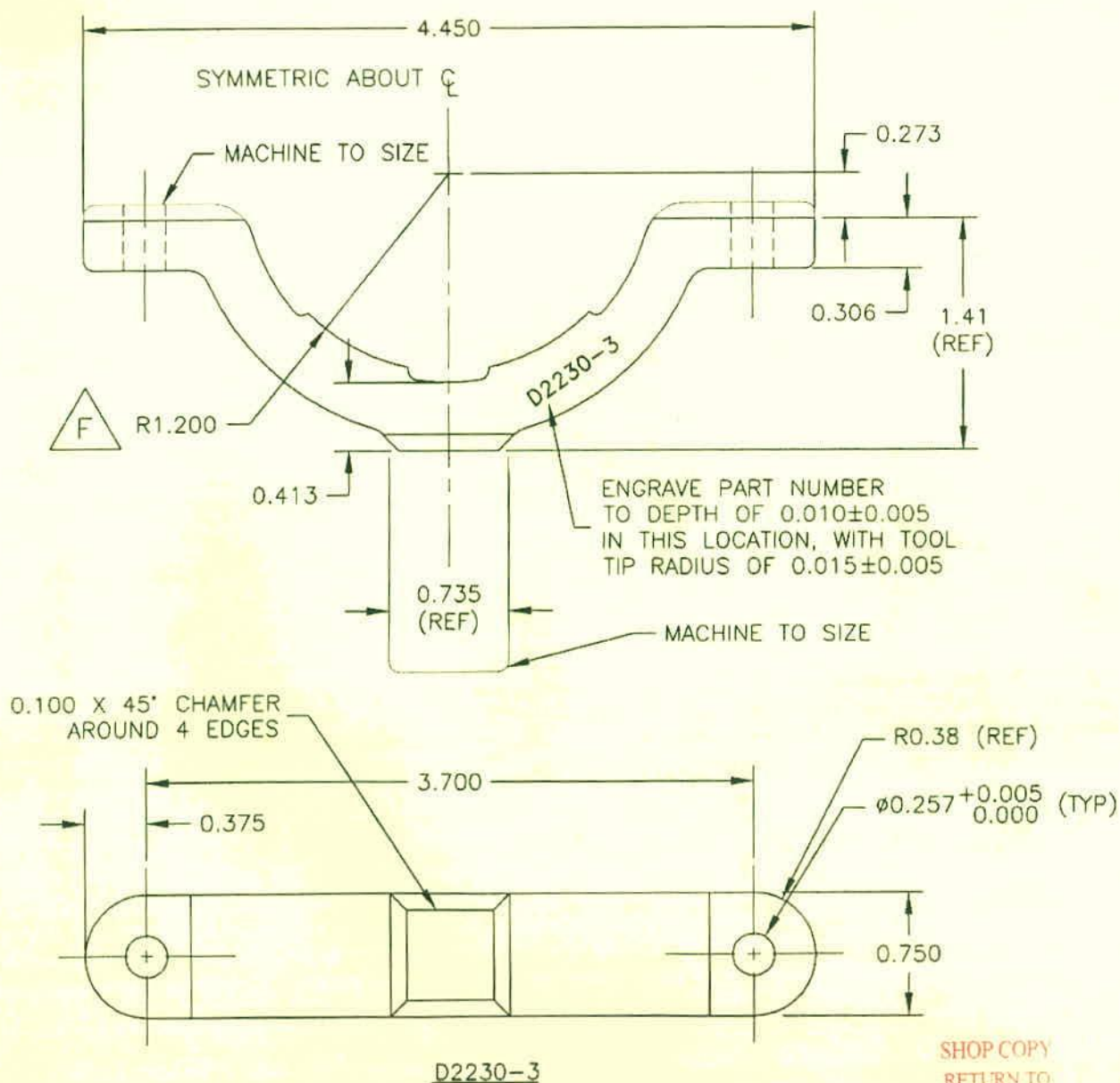






DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33250





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

160

D2230-1

Mounting Lug

4091

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Denise Robinson

Vankleek Hill, July 12, 2007







20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: **16003**  
Date: Jul 12, 2007  
Page: 1

<b>Sold to:</b>	<b>Ship to:</b>
<b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 4091 <i>en</i>	<b>Sold By:</b>
<b>Shipped By:</b> our truck	<b>Ship Date:</b> Jul 12, 2007

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1	Mounting Lug	Each	500	160	340
MATERIAL 2423 B30062 supplied by DART					
D3235-1	Mounting Lug	Each	600		600
D3338-1	Mounting Lug	Each	20		20
D3394-3	Lug	Each	40		40
<i>EP 7/12/07</i>					

Received by \_\_\_\_\_

**Thank you for your order!**

